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D4776-1
Job Sheet 184970



Part No: D4776-1

Job Qty: 20 ea

Part Name: Basket Strut Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Machining-3		
100	Doosan	20 pcs	11/12/18	11/12/18	0.54	10.64	Doosan		
105	QC	20 pcs	11/12/18	11/12/18	0.00	0.00	QC2 Machining-3		
111	QC	20 pcs	11/12/18	11/12/18	0.00	0.00	QC8 Machining-3		
112	HandFinish	20 pcs	11/12/18	11/12/18	0.00	0.57	HandFinish1		
113	QC	20 pcs	11/12/18	11/12/18	0.00	0.00	QC7-4		
115	Powdercoat	20 pcs	11/12/18	11/12/18	0.00	0.23	Powdercoat1		
116	QC	20 pcs	11/12/18	11/12/18	0.00	0.00	QC3		
130	Packaging	20 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-2		
140	QC21-SA	20 Ea	11/12/18	11/12/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Folio FB167 Dwg D4776 Rev: 2

Descriptions: 115 - MASK .403 ROUND SECTION AS PER DWG

M 138051 START: 8:00 O.T: 3:00 FINISH: 18:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R1.500	6061-T6 Round Bar 1.50	5.0000 ft (.29 ea)	90-Start up Operation	5123406

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R1.500	6	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Basket Strut Clevis	0.880Inches ± 0.030	0.910 0.850	8805	
2	Basket Strut Clevis	0.438Inches ± 0.010	0.448 0.428	.435	
3	Basket Strut Clevis	0.380Inches ± 0.030	0.410 0.350	.38	
4	Basket Strut Clevis	0.625Inches ± 0.010	0.635 0.615	.624	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5	Basket Strut Clevis	1.750Inches $\pm$ 0.030	1.780 1.720	1.753
6	Basket Strut Clevis	3.500Inches $\pm$ 0.030	3.530 3.470	3.504
7	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle 45°
8	Basket Strut Clevis	0.030Inches $\pm$ 0.030	0.060 0.000	.028
9	Basket Strut Clevis	0.060Inches $\pm$ 0.030	0.090 0.030	Radius R 1/16
10	Basket Strut Clevis	0.196Inches + 0.006 - 0.001	0.202 0.195	Diameter .198
11	Basket Strut Clevis	0.261Inches + 0.006 - 0.001	0.267 0.260	Diameter .262
12	Basket Strut Clevis	0.410Inches $\pm$ 0.030	0.440 0.380	Radius .408
13	Basket Strut Clevis	1.130Inches $\pm$ 0.030	1.160 1.100	1.129
14	Basket Strut Clevis	0.188Inches $\pm$ 0.010	0.198 0.178	.1885
15	Basket Strut Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	.191
16	Basket Strut Clevis	0.500Inches $\pm$ 0.030	0.530 0.470	.501
17	Basket Strut Clevis	0.750Inches $\pm$ 0.010	0.760 0.740	.75 .749
18	Basket Strut Clevis	0.403Inches + 0.000 - 0.005	0.403 0.398	Diameter .4005
19	Basket Strut Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius 1/8
20	Basket Strut Clevis	0.750Inches + 0.010 - 0.000	0.760 0.750	.753
21	Basket Strut Clevis	0.160Inches $\pm$ 0.030	0.190 0.130	.156
22	Basket Strut Clevis	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle 45°

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



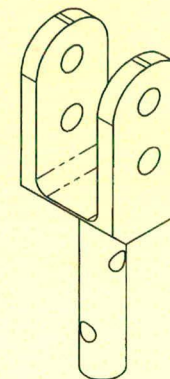
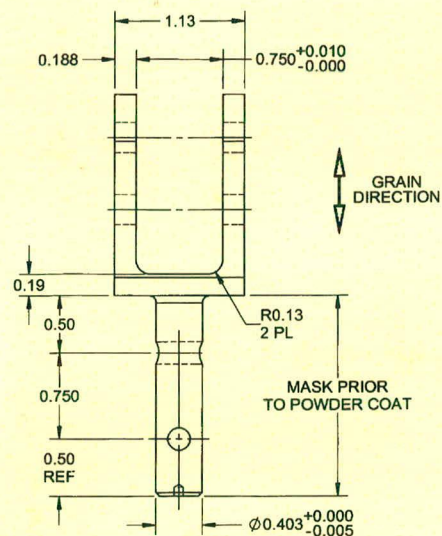
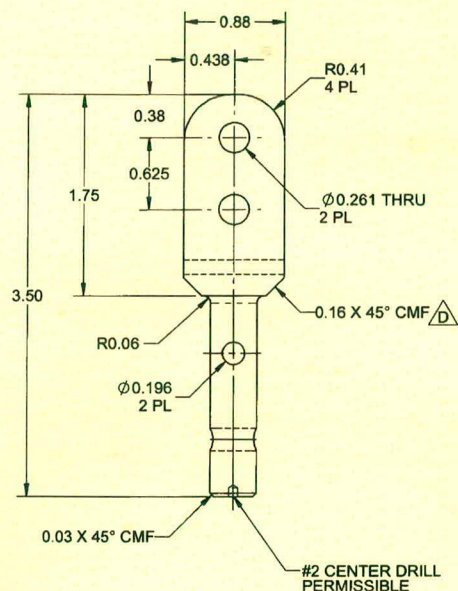
Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____			Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____			Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
			Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

JAKI AEROSPACE Inter Tribal Pa		1214 Amerueen Street Hawthornbury, ON K6B 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dentaro.com www.dentaro.space.com	
Container No: S126186			
Part: D4776-1			
Job No: 184970			
Serial No/Batch: S126186			
Revision:		Date: 11/08/18	
Inspector:		Date:	
Exp Date:		Instructions: Various STC's	

T CATEGORY			
Unqualified	Power Loss/Surge		Positioned Wrong
	Folio/Program		Outside Dimensions
	Grain		Over/Under tolerance
	Weld		Part Incorrect
	Wrong Stock Pulled		Part Lost/Missing
Unclear	Out of Sequence		Part Moved
	Off-set		Drawing
	Mislabeled		Finish
	Fit/Function		Misread
	Misaligned/off center		Turning Sequence



UNDER REVIEW
URF 18-803 SAD
18.09.12

RELEASED
2014-07-30

D4776-1 BASKET STRUT CLEVIS

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

D	SHT 1, C8 CHAMFER ADDED. SEE PAR 14-353. SHT 2 ZONE B2 1.813 DIM ADDED FOR CLARITY. ZONE B3 0.53 DIM CORRECTED TO 0.55 DUE TO DESIGN ERROR SEE PAR 14-328.	AJS	14.07.14
C	SHT 2, C7, 1.13 DIM WAS 0.88, C8 0.688 WAS 0.438, ADDED TOP VIEW WITH CHAMFERS. REASON: INTERFERENCE WITH OEM SADDLES.	AJS	13.10.31
B	MULTIPLE DIMENSIONS UPDATED ON -1 FOR INSTALLATION OF 1/4" FASTENERS. INDEX OF HOLES ON THE STEM OF -1 ROTATED 90°. FINISH ADDED TO -1. TOLERANCE ON CLEVIS FOR -1 & -3 TIGHTENED. ADDED -5. REASON: EASE OF INSTALLATION. C3-2 DEPTH DIM ADDED.	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4776 SHEET 1 OF 3 TITLE BASKET STRUT MACHINED PARTS SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.07.14		

